

**\*92124\***

October-23-12 2:33:56 PM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

\*2\*

**Cust Item ID:**

\*2\*

**Customer:**

**Reference:**

Run Start \*NR1\*

Stop \*NR2\*

|                 |                     |
|-----------------|---------------------|
| <b>Draw Nbr</b> | <b>Revision Nbr</b> |
| D3562           | Rev E               |

0.00

## Large Fab

Large Fab

## Memo

0.00

## Large Fab

1-Cut D2622 extrusion as per Dwg D3562

2-Deburr and bevel ends for welding

### 3-DRILL HOLES

110

QC6- Inspect dimensions to drawing

0.00

## Memo

0.00

QC

### Quality Control

120

Chemical Conversion Coat per QSI005 4.1

0.00

## Memo

0.00

HandFinish

### Hand Finishing

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

|  |             |             |            |   |                          |   |                        |                     |                     |  |  |
|--|-------------|-------------|------------|---|--------------------------|---|------------------------|---------------------|---------------------|--|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____ |             |             |            | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Work Order Update <input type="checkbox"/> |                          | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Thermoforming <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/><br/>           Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/><br/>           Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Quality <input type="checkbox"/><br/>           Other <input type="checkbox"/> </div> </div> |                        |                     |                     |  |  |
| <b>Root Cause</b>  | <b>Date</b> | <b>Step</b> | <b>Qty</b> | <b>Description of work order update or Non-conformance</b>  | <b>Initial Chief Eng</b> | <b>Action Description</b>   | <b>Sign &amp; Date</b> | <b>Verification</b> | <b>QC Inspector</b> |  |  |
| Doc/Data   |             |             |            |   |                          |   |                        |                     |                     |  |  |
| Equip/Tooling  |             |             |            |   |                          |   |                        |                     |                     |  |  |
| Operator   |             |             |            |   |                          |   |                        |                     |                     |  |  |
| Material   |             |             |            |   |                          |   |                        |                     |                     |  |  |
| Setup  |             |             |            |   |                          |   |                        |                     |                     |  |  |
| Other  |             |             |            |   |                          |   |                        |                     |                     |  |  |
| Process  |             |             |            |   |                          |   |                        |                     |                     |  |  |
| Supplier   |             |             |            |   |                          |   |                        |                     |                     |  |  |
| Training   |             |             |            |   |                          |   |                        |                     |                     |  |  |
| Unapproved   |             |             |            |   |                          |   |                        |                     |                     |  |  |

| FAULT CATEGORY  |   |   |   |  |
|---|---|---|---|--|
| <b>Landing Gear</b><br><input type="checkbox"/> Bending<br><input type="checkbox"/> Centre Not Concentric to O/S<br><input type="checkbox"/> Cracks<br><input type="checkbox"/> Crushed/Crimped<br><input type="checkbox"/> Cuffs<br><input type="checkbox"/> Heat Treat<br><input type="checkbox"/> Inspection Strip in Tube<br><input type="checkbox"/> Ripples in Bend<br><input type="checkbox"/> Torque Waves in Extrusion<br><input type="checkbox"/> Turning Sequence<br><input type="checkbox"/> Wave/Twist in Tube | <b>General</b><br><input type="checkbox"/> Bend<br><input type="checkbox"/> BOM/Route<br><input type="checkbox"/> Broken/Damaged<br><input type="checkbox"/> Burrs<br><input type="checkbox"/> Contamination<br><input type="checkbox"/> Countersink<br><input type="checkbox"/> Cut Too Short<br><input type="checkbox"/> Drill Holes<br><input type="checkbox"/> Drawing<br><input type="checkbox"/> Finish<br><input type="checkbox"/> Folio | <input type="checkbox"/> Grain<br><input type="checkbox"/> Hardware<br><input type="checkbox"/> Inspection Incomplete<br><input type="checkbox"/> Instructions Incomplete/Unclear<br><input type="checkbox"/> Maintenance<br><input type="checkbox"/> Mislabeled<br><input type="checkbox"/> Misread<br><input type="checkbox"/> Offset<br><input type="checkbox"/> Out of Calibration<br><input type="checkbox"/> Out of Sequence<br><input type="checkbox"/> Outside Dimensions | <input type="checkbox"/> Ovalized<br><input type="checkbox"/> Over/Under tolerance<br><input type="checkbox"/> Part Incorrect<br><input type="checkbox"/> Part Lost/Missing<br><input type="checkbox"/> Part Moved<br><input type="checkbox"/> Positioned Wrong<br><input type="checkbox"/> Power Loss/Surge<br><br><input type="checkbox"/> Pressure/Forced<br><input type="checkbox"/> Temperature/Cure<br><input type="checkbox"/> Weld<br><input type="checkbox"/> Wrong Stock Pulled<br><br><input type="checkbox"/> Other |  |

# Work Order ID 92124

\*92124\*

Page 2

October-23-12 2:33:56 PM

Item ID: D3562-042 Accept \*N900040100\* Setup Start \*NS1\*  
Revision ID: Stop \*NS2\*  
Item Name: Step Assembly, RH  
Start Date: 10/23/12 Start Qty: 2.00 \*2\* Cust Item ID:  
Required Date: 11/09/12 Req'd Qty: 2.00 \*2\* Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

| Sequence ID/<br>Work Center ID         | Operation<br>Description   | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp                |
|--|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|-------------------------------|
| 130<br>*130*<br>QC<br>Quality Control  | QC <del>7</del> Inspect Part Finish<br><br>Memo  | 0.00<br><br>0.00     |         |        |              | 2             | 2             |                  | DAS<br>19<br>9-89<br>13-03-28 |
| 140<br>*140*<br>Small Fab<br>Small Fab | Small Fab<br><br>Memo<br><del>1- Drill Rivet holes as per dwg D3562. Touch up alodine</del><br>2- Rivet legs using Magnabond as per dwg D3562.<br>*****Ensure to wipe off any excess magnabond *****<br>A/R Magnabond 6398 Batch: <u>M123022</u> | 0.00<br><br>0.00     |         |        |              | 2             | 0             |                  | 13-03-28                      |
| 150<br>*150*<br>QC<br>Quality Control  | QC5- Inspect part completeness to step on W/O<br><br>Memo  | 0.00<br><br>0.00     |         |        |              | 1             |               |                  | 13-04-25<br>DAS<br>09<br>9-89 |

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

|  |             |             |            |   |                          |   |                        |                     |                     |  |  |
|--|-------------|-------------|------------|---|--------------------------|---|------------------------|---------------------|---------------------|--|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____ |             |             |            | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Work Order Update <input type="checkbox"/> |                          | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Thermoforming <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/><br/>           Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/><br/>           Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Quality <input type="checkbox"/><br/>           Other <input type="checkbox"/> </div> </div> |                        |                     |                     |  |  |
| <b>Root Cause</b>  | <b>Date</b> | <b>Step</b> | <b>Qty</b> | <b>Description of work order update or Non-conformance</b>  | <b>Initial Chief Eng</b> | <b>Action Description</b>   | <b>Sign &amp; Date</b> | <b>Verification</b> | <b>QC Inspector</b> |  |  |
| Doc/Data <input type="checkbox"/>                            |             |             |            |   |                          |   |                        |                     |                     |  |  |
| Equip/Tooling <input type="checkbox"/>                       |             |             |            |   |                          |   |                        |                     |                     |  |  |
| Operator <input type="checkbox"/>                            |             |             |            |   |                          |   |                        |                     |                     |  |  |
| Material <input type="checkbox"/>                            |             |             |            |   |                          |   |                        |                     |                     |  |  |
| Setup <input type="checkbox"/>                               |             |             |            |   |                          |   |                        |                     |                     |  |  |
| Other <input type="checkbox"/>                               |             |             |            |   |                          |   |                        |                     |                     |  |  |
| Process <input type="checkbox"/>                             |             |             |            |   |                          |   |                        |                     |                     |  |  |
| Supplier <input type="checkbox"/>                            |             |             |            |   |                          |   |                        |                     |                     |  |  |
| Training <input type="checkbox"/>                            |             |             |            |   |                          |   |                        |                     |                     |  |  |
| Unapproved <input type="checkbox"/>                          |             |             |            |   |                          |   |                        |                     |                     |  |  |

| FAULT CATEGORY  |   |   |  |   |
|---|---|---|--|---|
| <b>Landing Gear</b><br><input type="checkbox"/> Bending<br><input type="checkbox"/> Centre Not Concentric to O/S<br><input type="checkbox"/> Cracks<br><input type="checkbox"/> Crushed/Crimped<br><input type="checkbox"/> Cuffs<br><input type="checkbox"/> Heat Treat<br><input type="checkbox"/> Inspection Strip in Tube<br><input type="checkbox"/> Ripples in Bend<br><input type="checkbox"/> Torque Waves in Extrusion<br><input type="checkbox"/> Turning Sequence<br><input type="checkbox"/> Wave/Twist in Tube | <b>General</b><br><input type="checkbox"/> Bend<br><input type="checkbox"/> BOM/Route<br><input type="checkbox"/> Broken/Damaged<br><input type="checkbox"/> Burrs<br><input type="checkbox"/> Contamination<br><input type="checkbox"/> Countersink<br><input type="checkbox"/> Cut Too Short<br><input type="checkbox"/> Drill Holes<br><input type="checkbox"/> Drawing<br><input type="checkbox"/> Finish<br><input type="checkbox"/> Folio | <input type="checkbox"/> Grain<br><input type="checkbox"/> Hardware<br><input type="checkbox"/> Inspection Incomplete<br><input type="checkbox"/> Instructions Incomplete/Unclear<br><input type="checkbox"/> Maintenance<br><input type="checkbox"/> Mislabeled<br><input type="checkbox"/> Misread<br><input type="checkbox"/> Offset<br><input type="checkbox"/> Out of Calibration<br><input type="checkbox"/> Out of Sequence<br><input type="checkbox"/> Outside Dimensions | <input type="checkbox"/> Ovalized<br><input type="checkbox"/> Over/Under tolerance<br><input type="checkbox"/> Part Incorrect<br><input type="checkbox"/> Part Lost/Missing<br><input type="checkbox"/> Part Moved<br><input type="checkbox"/> Positioned Wrong<br><input type="checkbox"/> Power Loss/Surge | <input type="checkbox"/> Pressure/Forced<br><input type="checkbox"/> Temperature/Cure<br><input type="checkbox"/> Weld<br><input type="checkbox"/> Wrong Stock Pulled<br><input type="checkbox"/> Other |

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18  
8-89

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

|   |      |      |   |   |                      |   |                |              |  |  |   |  |
|---|------|------|---|---|----------------------|---|----------------|--------------|--|--|---|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____  |      |      |   | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Work Order Update <input type="checkbox"/> |                      | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Thermoforming <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/><br/>           Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/><br/>           Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Quality <input type="checkbox"/><br/>           Other <input type="checkbox"/> </div> </div> |                |              |  |  |   |  |
| <b>Root Cause</b>   | Date | Step | Qty   | Description of work order update<br>or Non-conformance  | Initial<br>Chief Eng | Action<br>Description   | Sign &<br>Date | Verification | QC Inspector   |  |   |  |
| Doc/Data <input type="checkbox"/>   |      |      |   |   |                      |   |                |              |  |  |   |  |
| Equip/Tooling <input type="checkbox"/>  |      |      |   |   |                      |   |                |              |  |  |   |  |
| Operator <input type="checkbox"/>   |      |      |   |   |                      |   |                |              |  |  |   |  |
| Material <input type="checkbox"/>   |      |      |   |   |                      |   |                |              |  |  |   |  |
| Setup <input type="checkbox"/>  |      |      |   |   |                      |   |                |              |  |  |   |  |
| Other <input type="checkbox"/>  |      |      |   |   |                      |   |                |              |  |  |   |  |
| Process <input type="checkbox"/>  |      |      |   |   |                      |   |                |              |  |  |   |  |
| Supplier <input type="checkbox"/>   |      |      |   |   |                      |   |                |              |  |  |   |  |
| Training <input type="checkbox"/>   |      |      |   |   |                      |   |                |              |  |  |   |  |
| Unapproved <input type="checkbox"/>   |      |      |   |   |                      |   |                |              |  |  |   |  |
| <b>FAULT CATEGORY</b>   |      |      |   |   |                      |   |                |              |  |  |   |  |
| <b>Landing Gear</b><br><input type="checkbox"/> Bending<br><input type="checkbox"/> Centre Not Concentric to O/S<br><input type="checkbox"/> Cracks<br><input type="checkbox"/> Crushed/Crimped<br><input type="checkbox"/> Cuffs<br><input type="checkbox"/> Heat Treat<br><input type="checkbox"/> Inspection Strip in Tube<br><input type="checkbox"/> Ripples in Bend<br><input type="checkbox"/> Torque Waves in Extrusion<br><input type="checkbox"/> Turning Sequence<br><input type="checkbox"/> Wave/Twist in Tube |      |      | <b>General</b><br><input type="checkbox"/> Bend<br><input type="checkbox"/> BOM/Route<br><input type="checkbox"/> Broken/Damaged<br><input type="checkbox"/> Burrs<br><input type="checkbox"/> Contamination<br><input type="checkbox"/> Countersink<br><input type="checkbox"/> Cut Too Short<br><input type="checkbox"/> Drill Holes<br><input type="checkbox"/> Drawing<br><input type="checkbox"/> Finish<br><input type="checkbox"/> Folio |   |                      | <input type="checkbox"/> Grain<br><input type="checkbox"/> Hardware<br><input type="checkbox"/> Inspection Incomplete<br><input type="checkbox"/> Instructions Incomplete/Unclear<br><input type="checkbox"/> Maintenance<br><input type="checkbox"/> Mislabeled<br><input type="checkbox"/> Misread<br><input type="checkbox"/> Offset<br><input type="checkbox"/> Out of Calibration<br><input type="checkbox"/> Out of Sequence<br><input type="checkbox"/> Outside Dimensions   |                |              | <input type="checkbox"/> Ovalized<br><input type="checkbox"/> Over/Under tolerance<br><input type="checkbox"/> Part Incorrect<br><input type="checkbox"/> Part Lost/Missing<br><input type="checkbox"/> Part Moved<br><input type="checkbox"/> Positioned Wrong<br><input type="checkbox"/> Power Loss/Surge |  | <input type="checkbox"/> Pressure/Forced<br><input type="checkbox"/> Temperature/Cure<br><input type="checkbox"/> Weld<br><input type="checkbox"/> Wrong Stock Pulled<br><input type="checkbox"/> Other |  |

# Work Order ID 92124

**\*92124\***

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October-23-12 2:33:56 PM

Item ID: D3562-042

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Step Assembly, RH

Start Date: 10/23/12 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 11/09/12 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

190

Chemical Conversion Coat per QSI005 4.1

0.00

**\*190\***

HandFinish

Memo

0.00

Hand Finishing

RH 2X M-F 13/04/30

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*200\***

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:20  
320°F  
10:50  
125/82

RH 2X M-F 13/04/30

M125064

210

Wing Walk as per dwg QSI005 4.4 Batch

0.00

**\*210\***

HandFinish

Memo

0.00

Hand Finishing

2 6 13-4-30

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: date Date: 13/08/02QA Closed: OK Date: 13/5/15

|  |  |  |  |  |  |  |  |  |  |  |  |
|--|--|--|--|--|--|--|--|--|--|--|--|
| Work Order: <u>92124</u><br>Part No. <u>D 3562-042</u><br>NCR No. <u>13-2609</u> |  |  |  | <b>DISPOSITION</b><br>Rework <input checked="" type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Work Order Update <input type="checkbox"/> |  | <b>AGAINST DEPARTMENT/PROCESS</b><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Thermoforming <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input checked="" type="checkbox"/><br/>           Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/><br/>           Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Quality <input type="checkbox"/><br/>           Other <input type="checkbox"/> </div> </div> |  |  |  |  |  |
|--|--|--|--|--|--|--|--|--|--|--|--|

| Root Cause                                  | Date     | Step  | Qty | Description of work order update or Non-conformance  | Initial Chief Eng                 | Action Description   | Sign & Date                      | Verification  | QC Inspector                      |
|---|----------|-------|-----|--|-----------------------------------|--|----------------------------------|---------------|-----------------------------------|
| Doc/Data <input type="checkbox"/>           | 13/04/30 | # 200 | X1  | Magnaflux looked through the Plc on ch x1 slip.<br><br>R.C. not clean enough.<br><br><i>landing preservation</i> | DAS 16 9-89<br>027042<br>13/04/30 | Strain entri slip<br>As per 027004<br>Re Alcu as if using.<br>Re Power Unit as per 027004<br>Start 1-30 - Find 2-00<br>temp 32001 - temp | 13/04/30<br>13/04/30<br>13/04/30 | 5<br>13/05/14 | DAS 16 9-89<br>027042<br>13/04/30 |
| Equip/Tooling <input type="checkbox"/>      |          |       |     |  |                                   |  |                                  |               |                                   |
| Operator <input type="checkbox"/>           |          |       |     |  |                                   |  |                                  |               |                                   |
| Material <input type="checkbox"/>           |          |       |     |  |                                   |  |                                  |               |                                   |
| Setup <input type="checkbox"/>              |          |       |     |  |                                   |  |                                  |               |                                   |
| Other <input type="checkbox"/>              |          |       |     |  |                                   |  |                                  |               |                                   |
| Process <input checked="" type="checkbox"/> |          |       |     |  |                                   |  |                                  |               |                                   |
| Supplier <input type="checkbox"/>           |          |       |     |  |                                   |  |                                  |               |                                   |
| Training <input type="checkbox"/>           |          |       |     |  |                                   |  |                                  |               |                                   |
| Unapproved <input type="checkbox"/>         |          |       |     |  |                                   |  |                                  |               |                                   |

| FAULT CATEGORY   |   |   |   |
|--|---|---|---|
| <b>Landing Gear</b><br><input type="checkbox"/> Bending<br><input type="checkbox"/> Centre Not Concentric to O/S<br><input type="checkbox"/> Cracks<br><input type="checkbox"/> Crushed/Crimped.<br><input type="checkbox"/> Cuffs<br><input type="checkbox"/> Heat Treat<br><input type="checkbox"/> Inspection Strip in Tube<br><input type="checkbox"/> Ripples in Bend<br><input type="checkbox"/> Torque Waves in Extrusion<br><input type="checkbox"/> Turning Sequence<br><input type="checkbox"/> Wave/Twist in Tube | <b>General</b><br><input type="checkbox"/> Bend<br><input type="checkbox"/> BOM/Route<br><input type="checkbox"/> Broken/Damaged<br><input type="checkbox"/> Burrs<br><input type="checkbox"/> Contamination<br><input type="checkbox"/> Countersink<br><input type="checkbox"/> Cut Too Short<br><input type="checkbox"/> Drill Holes<br><input type="checkbox"/> Drawing<br><input type="checkbox"/> Finish<br><input type="checkbox"/> Folio | <input type="checkbox"/> Grain<br><input type="checkbox"/> Hardware<br><input type="checkbox"/> Inspection Incomplete<br><input type="checkbox"/> Instructions Incomplete/Unclear<br><input type="checkbox"/> Maintenance<br><input type="checkbox"/> Mislabeled<br><input type="checkbox"/> Misread<br><input type="checkbox"/> Offset<br><input type="checkbox"/> Out of Calibration<br><input type="checkbox"/> Out of Sequence<br><input type="checkbox"/> Outside Dimensions | <input type="checkbox"/> Ovalized<br><input type="checkbox"/> Over/Under tolerance<br><input type="checkbox"/> Part Incorrect<br><input type="checkbox"/> Part Lost/Missing<br><input type="checkbox"/> Part Moved<br><input type="checkbox"/> Positioned Wrong<br><input type="checkbox"/> Power Loss/Surge<br><input type="checkbox"/> Pressure/Forced<br><input type="checkbox"/> Temperature/Cure<br><input type="checkbox"/> Weld<br><input type="checkbox"/> Wrong Stock Pulled<br><input type="checkbox"/> Other |



# Work Order ID 92124

\*92124\*

Page 5

October-23-12 2:33:56 PM

Item ID: D3562-042 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Step Assembly, RH  
 Start Date: 10/23/12 Start Qty: 2.00 \*2\* Cust Item ID:  
 Required Date: 11/09/12 Req'd Qty: 2.00 \*2\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description                    | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 220                            | QC3- Inspect Part Finish                    | 0.00                 |         |        |              |               |               |                  |                |
| *220*                          |   |                      |         |        |              | 2x            |               |                  | 13/5/01        |
| QC                             | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |   |                      |         |        |              |               |               |                  |                |
| 230                            | Identify as per dwg & Stock Location        | 0.00                 |         |        |              |               |               |                  |                |
| *230*                          |   |                      |         |        |              | 2x            |               |                  | 13/5/01        |
| Packaging                      | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Packaging                      |   |                      |         |        |              |               |               |                  |                |
| 240                            | QC21- Final Inspection - Work Order Release | 0.00                 |         |        |              |               |               |                  |                |
| *240*                          |   |                      |         |        |              |               |               |                  | 13/5/3         |
| QC                             | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |   |                      |         |        |              |               |               |                  |                |

13-05-3

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

|   |      |      |   |   |                      |   |                |   |              |  |  |
|---|------|------|---|---|----------------------|---|----------------|---|--------------|--|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____  |      |      |   | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Work Order Update <input type="checkbox"/> |                      | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Thermoforming <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/><br/>           Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/><br/>           Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Quality <input type="checkbox"/><br/>           Other <input type="checkbox"/> </div> </div> |                |   |              |  |  |
| <b>Root Cause</b>   | Date | Step | Qty   | Description of work order update<br>or Non-conformance  | Initial<br>Chief Eng | Action<br>Description   | Sign &<br>Date | Verification  | QC Inspector |  |  |
| Doc/Data <input type="checkbox"/>   |      |      |   |   |                      |   |                |   |              |  |  |
| Equip/Tooling <input type="checkbox"/>  |      |      |   |   |                      |   |                |   |              |  |  |
| Operator <input type="checkbox"/>   |      |      |   |   |                      |   |                |   |              |  |  |
| Material <input type="checkbox"/>   |      |      |   |   |                      |   |                |   |              |  |  |
| Setup <input type="checkbox"/>  |      |      |   |   |                      |   |                |   |              |  |  |
| Other <input type="checkbox"/>  |      |      |   |   |                      |   |                |   |              |  |  |
| Process <input type="checkbox"/>  |      |      |   |   |                      |   |                |   |              |  |  |
| Supplier <input type="checkbox"/>   |      |      |   |   |                      |   |                |   |              |  |  |
| Training <input type="checkbox"/>   |      |      |   |   |                      |   |                |   |              |  |  |
| Unapproved <input type="checkbox"/>   |      |      |   |   |                      |   |                |   |              |  |  |
| <b>FAULT CATEGORY</b>   |      |      |   |   |                      |   |                |   |              |  |  |
| <b>Landing Gear</b><br><input type="checkbox"/> Bending<br><input type="checkbox"/> Centre Not Concentric to O/S<br><input type="checkbox"/> Cracks<br><input type="checkbox"/> Crushed/Crimped<br><input type="checkbox"/> Cuffs<br><input type="checkbox"/> Heat Treat<br><input type="checkbox"/> Inspection Strip in Tube<br><input type="checkbox"/> Ripples in Bend<br><input type="checkbox"/> Torque Waves in Extrusion<br><input type="checkbox"/> Turning Sequence<br><input type="checkbox"/> Wave/Twist in Tube |      |      | <b>General</b><br><input type="checkbox"/> Bend<br><input type="checkbox"/> BOM/Route<br><input type="checkbox"/> Broken/Damaged<br><input type="checkbox"/> Burrs<br><input type="checkbox"/> Contamination<br><input type="checkbox"/> Countersink<br><input type="checkbox"/> Cut Too Short<br><input type="checkbox"/> Drill Holes<br><input type="checkbox"/> Drawing<br><input type="checkbox"/> Finish<br><input type="checkbox"/> Folio |   |                      | <input type="checkbox"/> Grain<br><input type="checkbox"/> Hardware<br><input type="checkbox"/> Inspection Incomplete<br><input type="checkbox"/> Instructions Incomplete/Unclear<br><input type="checkbox"/> Maintenance<br><input type="checkbox"/> Mislabeled<br><input type="checkbox"/> Misread<br><input type="checkbox"/> Offset<br><input type="checkbox"/> Out of Calibration<br><input type="checkbox"/> Out of Sequence<br><input type="checkbox"/> Outside Dimensions   |                | <input type="checkbox"/> Ovalized<br><input type="checkbox"/> Over/Under tolerance<br><input type="checkbox"/> Part Incorrect<br><input type="checkbox"/> Part Lost/Missing<br><input type="checkbox"/> Part Moved<br><input type="checkbox"/> Positioned Wrong<br><input type="checkbox"/> Power Loss/Surge<br><br><input type="checkbox"/> Pressure/Forced<br><input type="checkbox"/> Temperature/Cure<br><input type="checkbox"/> Weld<br><input type="checkbox"/> Wrong Stock Pulled<br><br><input type="checkbox"/> Other |              |  |  |

# Picklist Print

October-23-12 2:33:55 PM

Page 1

Work Order ID: 92124  
 Parent Item: D3562-042  
 Parent Item Name: Step Assembly, RH

Start Date: 10/23/12  
 Start Qty: 2.00

Required Date: 11/09/12  
 Required Qty: 2.00

Comments: IPP Rev:A New Issue 06-11-09 JLM  
 IPP rev B ECN 987 07.10.09 EC verified by: DD  
 IPP Rev:C ECN1048 07-12-18 DD verified by: EC  
 IPP Rev:D 08-07-28 add chemical conversion coat DD verified by:EC

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

|                              |  |              |    |  |  |     |      |          |  |  |  |  |  |
|------------------------------|--|--------------|----|--|--|-----|------|----------|--|--|--|--|--|
| D2622-120C<br>Step Extrusion |  | Manufactured | No |  |  | 100 | Each | 204.2300 |  |  |  |  |  |
|------------------------------|--|--------------|----|--|--|-----|------|----------|--|--|--|--|--|

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| HALL     | 16.37   |          |
| 46910    | 2       |          |
| 64409    | 6       |          |
| 66970    | 7.7     |          |
| 68293    | 0.25    |          |
| 72131    | 0.42    |          |
| WA       | 178.5   |          |
| 81507    | 1.88    |          |
| 83894    | 12.38   |          |
| 88513    | 24.24   |          |
| 89750    | 140     |          |
| WA013    | 9.36    |          |
| 75781    | 2       |          |
| 77612    | 7.36    |          |

1 B9352 → ② Ac  
 13.02.13

|                         |  |              |    |  |  |     |      |          |  |  |  |  |  |
|-------------------------|--|--------------|----|--|--|-----|------|----------|--|--|--|--|--|
| D2734<br>Step End Plate |  | Manufactured | No |  |  | 140 | Each | 167.0000 |  |  |  |  |  |
|-------------------------|--|--------------|----|--|--|-----|------|----------|--|--|--|--|--|

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA       | 167     |          |
| 80682    | 6       |          |
| 84563    | 11      |          |
| 88714    | 45      |          |
| 91761    | 105     |          |

2 4  
 13.04.25

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

|   |      |      |   |   |                      |   |                |              |   |  |  |
|---|------|------|---|---|----------------------|---|----------------|--------------|---|--|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____  |      |      |   | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Work Order Update <input type="checkbox"/> |                      | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Thermoforming <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/><br/>           Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/><br/>           Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Quality <input type="checkbox"/><br/>           Other <input type="checkbox"/> </div> </div> |                |              |   |  |  |
| <b>Root Cause</b>   | Date | Step | Qty   | Description of work order update<br>or Non-conformance  | Initial<br>Chief Eng | Action<br>Description   | Sign &<br>Date | Verification | QC Inspector  |  |  |
| Doc/Data <input type="checkbox"/>   |      |      |   |   |                      |   |                |              |   |  |  |
| Equip/Tooling <input type="checkbox"/>  |      |      |   |   |                      |   |                |              |   |  |  |
| Operator <input type="checkbox"/>   |      |      |   |   |                      |   |                |              |   |  |  |
| Material <input type="checkbox"/>   |      |      |   |   |                      |   |                |              |   |  |  |
| Setup <input type="checkbox"/>  |      |      |   |   |                      |   |                |              |   |  |  |
| Other <input type="checkbox"/>  |      |      |   |   |                      |   |                |              |   |  |  |
| Process <input type="checkbox"/>  |      |      |   |   |                      |   |                |              |   |  |  |
| Supplier <input type="checkbox"/>   |      |      |   |   |                      |   |                |              |   |  |  |
| Training <input type="checkbox"/>   |      |      |   |   |                      |   |                |              |   |  |  |
| Unapproved <input type="checkbox"/>   |      |      |   |   |                      |   |                |              |   |  |  |
| <b>FAULT CATEGORY</b>   |      |      |   |   |                      |   |                |              |   |  |  |
| <b>Landing Gear</b><br><input type="checkbox"/> Bending<br><input type="checkbox"/> Centre Not Concentric to O/S<br><input type="checkbox"/> Cracks<br><input type="checkbox"/> Crushed/Crimped<br><input type="checkbox"/> Cuffs<br><input type="checkbox"/> Heat Treat<br><input type="checkbox"/> Inspection Strip in Tube<br><input type="checkbox"/> Ripples in Bend<br><input type="checkbox"/> Torque Waves in Extrusion<br><input type="checkbox"/> Turning Sequence<br><input type="checkbox"/> Wave/Twist in Tube |      |      | <b>General</b><br><input type="checkbox"/> Bend<br><input type="checkbox"/> BOM/Route<br><input type="checkbox"/> Broken/Damaged<br><input type="checkbox"/> Burrs<br><input type="checkbox"/> Contamination<br><input type="checkbox"/> Countersink<br><input type="checkbox"/> Cut Too Short<br><input type="checkbox"/> Drill Holes<br><input type="checkbox"/> Drawing<br><input type="checkbox"/> Finish<br><input type="checkbox"/> Folio |   |                      | <input type="checkbox"/> Grain<br><input type="checkbox"/> Hardware<br><input type="checkbox"/> Inspection Incomplete<br><input type="checkbox"/> Instructions Incomplete/Unclear<br><input type="checkbox"/> Maintenance<br><input type="checkbox"/> Mislabeled<br><input type="checkbox"/> Misread<br><input type="checkbox"/> Offset<br><input type="checkbox"/> Out of Calibration<br><input type="checkbox"/> Out of Sequence<br><input type="checkbox"/> Outside Dimensions   |                |              | <input type="checkbox"/> Ovalized<br><input type="checkbox"/> Over/Under tolerance<br><input type="checkbox"/> Part Incorrect<br><input type="checkbox"/> Part Lost/Missing<br><input type="checkbox"/> Part Moved<br><input type="checkbox"/> Positioned Wrong<br><input type="checkbox"/> Power Loss/Surge<br><br><input type="checkbox"/> Pressure/Forced<br><input type="checkbox"/> Temperature/Cure<br><input type="checkbox"/> Weld<br><input type="checkbox"/> Wrong Stock Pulled<br><br><input type="checkbox"/> Other |  |  |

# Picklist Print

October-23-12 2:33:56 PM

Page 2

Work Order ID: 92124  
Parent Item: D3562-042  
Parent Item Name: Step Assembly, RH

Start Date: 10/23/12 Required Date: 11/09/12  
Start Qty: 2.00 Required Qty: 2.00

D3560-042 Manufactured No 140 Each 2.0000  
Arm Weldment

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA       | 2       |          |
| 85384    | 2       |          |

<sup>1</sup> ~~B80260~~ → (3) Ae  
13.03.18

D3560-044 Manufactured No 140 Each 4.0000  
Arm Weldment

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA       | 3       |          |
| 85386    | 3       |          |
| WA013    | 1       |          |
| 71950    | 1       |          |

<sup>1</sup> ~~B80262~~ → (2) Ae  
13.03.18

MS20600-AD4W5 Purchased No 160 Each 559.0000  
Blind Rivet

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST321    | 516     |          |
| 121255   | 19      |          |
| 121349   | 200     |          |
| 121652   | 297     |          |
| WA018    | 43      |          |
| 118384   | 43      |          |

<sup>32</sup> ~~M123900~~ → (30) Ae  
<sup>64</sup> ~~M124862~~ → 34 13.03.21

October-23-12 2:33:56 PM

Shop Packet Print

Page 2

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

|   |             |             |   |   |                          |   |                        |                     |   |  |  |
|---|-------------|-------------|---|---|--------------------------|---|------------------------|---------------------|---|--|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____  |             |             |   | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Work Order Update <input type="checkbox"/> |                          | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Thermoforming <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/><br/>           Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/><br/>           Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Quality <input type="checkbox"/><br/>           Other <input type="checkbox"/> </div> </div> |                        |                     |   |  |  |
| <b>Root Cause</b>   | <b>Date</b> | <b>Step</b> | <b>Qty</b>  | <b>Description of work order update or Non-conformance</b>  | <b>Initial Chief Eng</b> | <b>Action Description</b>   | <b>Sign &amp; Date</b> | <b>Verification</b> | <b>QC Inspector</b>   |  |  |
| Doc/Data <input type="checkbox"/>   |             |             |   |   |                          |   |                        |                     |   |  |  |
| Equip/Tooling <input type="checkbox"/>  |             |             |   |   |                          |   |                        |                     |   |  |  |
| Operator <input type="checkbox"/>   |             |             |   |   |                          |   |                        |                     |   |  |  |
| Material <input type="checkbox"/>   |             |             |   |   |                          |   |                        |                     |   |  |  |
| Setup <input type="checkbox"/>  |             |             |   |   |                          |   |                        |                     |   |  |  |
| Other <input type="checkbox"/>  |             |             |   |   |                          |   |                        |                     |   |  |  |
| Process <input type="checkbox"/>  |             |             |   |   |                          |   |                        |                     |   |  |  |
| Supplier <input type="checkbox"/>   |             |             |   |   |                          |   |                        |                     |   |  |  |
| Training <input type="checkbox"/>   |             |             |   |   |                          |   |                        |                     |   |  |  |
| Unapproved <input type="checkbox"/>   |             |             |   |   |                          |   |                        |                     |   |  |  |
| <b>FAULT CATEGORY</b>   |             |             |   |   |                          |   |                        |                     |   |  |  |
| <b>Landing Gear</b><br><input type="checkbox"/> Bending<br><input type="checkbox"/> Centre Not Concentric to O/S<br><input type="checkbox"/> Cracks<br><input type="checkbox"/> Crushed/Crimped<br><input type="checkbox"/> Cuffs<br><input type="checkbox"/> Heat Treat<br><input type="checkbox"/> Inspection Strip in Tube<br><input type="checkbox"/> Ripples in Bend<br><input type="checkbox"/> Torque Waves in Extrusion<br><input type="checkbox"/> Turning Sequence<br><input type="checkbox"/> Wave/Twist in Tube |             |             | <b>General</b><br><input type="checkbox"/> Bend<br><input type="checkbox"/> BOM/Route<br><input type="checkbox"/> Broken/Damaged<br><input type="checkbox"/> Burrs<br><input type="checkbox"/> Contamination<br><input type="checkbox"/> Countersink<br><input type="checkbox"/> Cut Too Short<br><input type="checkbox"/> Drill Holes<br><input type="checkbox"/> Drawing<br><input type="checkbox"/> Finish<br><input type="checkbox"/> Folio |   |                          | <input type="checkbox"/> Grain<br><input type="checkbox"/> Hardware<br><input type="checkbox"/> Inspection Incomplete<br><input type="checkbox"/> Instructions Incomplete/Unclear<br><input type="checkbox"/> Maintenance<br><input type="checkbox"/> Mislabeled<br><input type="checkbox"/> Misread<br><input type="checkbox"/> Offset<br><input type="checkbox"/> Out of Calibration<br><input type="checkbox"/> Out of Sequence<br><input type="checkbox"/> Outside Dimensions   |                        |                     | <input type="checkbox"/> Ovalized<br><input type="checkbox"/> Over/Under tolerance<br><input type="checkbox"/> Part Incorrect<br><input type="checkbox"/> Part Lost/Missing<br><input type="checkbox"/> Part Moved<br><input type="checkbox"/> Positioned Wrong<br><input type="checkbox"/> Power Loss/Surge<br><br><input type="checkbox"/> Pressure/Forced<br><input type="checkbox"/> Temperature/Cure<br><input type="checkbox"/> Weld<br><input type="checkbox"/> Wrong Stock Pulled<br><br><input type="checkbox"/> Other |  |  |

D3562-1.  
MAKE FROM  
EXTRUSION D2622

D3560-043 ARM WELDMENT

D3560-041 ARM WELDMENT

D3560-044 ARM WELDMENT

D3560-042 ARM WELDMENT

D3562-1.  
MAKE FROM  
EXTRUSION D2622

2  
APPLY BLACK  
ANTI-SKID ON  
TOP SURFACE  
TO BOTTOM  
OF TOP RADIUS

2  
APPLY BLACK  
ANTI-SKID ON  
TOP SURFACE  
TO BOTTOM  
OF TOP RADIUS

TRANSFER DRILL #30  
DEBURR & TOUCH UP HOLES  
WITH CHEMICAL CONVERSION  
COAT BEFORE RIVETING  
(32 PLACES PER STEP)

REFER TO STEP  
END DETAIL

INSTALL MS20600AD4W5 RIVET  
(32 PLACES PER STEP)

4.30 71.707 9.15 (REF)  
85.15  
MEASURED BEFORE END CAPS WELDED IN PLACE  
FWD

9.15 (REF) 71.707 4.30  
85.15  
MEASURED BEFORE END CAPS WELDED IN PLACE  
FWD

ROUND CORNER OF EXTRUSION TO  
MATCH BEND RADIUS OF END PLATE

NOTE: ALL WELDS SHALL BE 100%  
VISUALLY INSPECTED BY A  
QUALIFIED INSPECTOR PER  
DART QSI 004

D2734 END PLATE  
(TYP 2 PLACES)  
TYPICAL STEP END DETAIL  
SCALE 1:2

### D3562-041 LH STEP ASSEMBLY

### D3562-042 RH STEP ASSEMBLY

#### NOTES:

1) MATERIAL: N/A

2) FINISH:

i) CHEMICAL CONVERSION COAT STEP EXTRUSION  
PER DART QSI 005 4.1 BEFORE ASSEMBLY

ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR  
GREY SANDTEX (4.3.5.6) OR  
BLACK SANDTEX (4.3.5.7) OR  
GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 8.79 lbs

8) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN  
THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH  
MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.

9) WELDING: PER DART QSI 004

| QTY<br>-041 | QTY<br>-042 | P/N          | DESCRIPTION      |
|-------------|-------------|--------------|------------------|
| X           | X           | D3562-041    | LH STEP ASSEMBLY |
|             |             | D3562-042    | RH STEP ASSEMBLY |
| 1           |             | D3560-041    | ARM WELDMENT     |
|             | 1           | D3560-042    | ARM WELDMENT     |
| 1           |             | D3560-043    | ARM WELDMENT     |
|             | 1           | D3560-044    | ARM WELDMENT     |
| 32          | 32          | MS20600AD4W5 | RIVET            |
| 2           | 2           | D2734        | END PLATE        |

|            |  |    |          |
|------------|--|----|----------|
| E          | ADD QTY (2) TO D2734 END PLATE ON D3562-042        | PH | 08.01.11 |
| D          | REMOVE D2800 SPACER NOTE: REDRAWN IN<br>SOLIDWORKS | DC | 07.11.16 |
| C          | NOW MAGNOBOND. ADD D2808, REMOVE 4 RIVETS          | CP | 07.06.19 |
| B          | ARMS NOW RIVETED TO STEP                           | CP | 07.01.15 |
| A          | NEW ISSUE  | CP | 06.09.26 |
| REV.       | DESCRIPTION  | BY | DATE     |
| DESIGN     |  |    |          |
| DRAWN      |  |    |          |
| CHECKED    |  |    |          |
| MFG. APPR. |  |    |          |
| APPROVED   |  |    |          |
| DE APPR.   |  |    |          |
| DATE       | 08.01.11   |    |          |

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.  
**D3562** REV. E  
SHEET 1 OF 1

TITLE  
**STEP ASSEMBLY** SCALE  
1:5

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SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER

NO. 92124 ML5

12-10-24